Work Orde		5550		*105	555	0 *			•			Page 1
Revision ID:	D3065-5 Step Leg			Accept	*N	900	040	100)* s	etup Star	į VI,	S1* S2*
Start Date: Required Date: Reference:	8/08/13 8/08/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*			ust Item I ustomer:	D:					
Approvals:			Date: 13-08-08				ite:		R	un Star Sto	n 1 \1	R1* R2*
Sequence ID/ Work Center ID Draw Nbr) 	Operation Description ision Nbr		Set Up/ Run Hours		Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
D3065 100 *100* Waterjet FLOW CNC Waterje	Rev	FLOW WATER JET Memo	Dwg D Dwg Rev:	0.00 0.00 Prog Rev:	2-Deburr				_20			<u>Jm13-</u> 08-23
*110 *110* QC Quality Control		QC2- Inspect parts off ma	achine FAI/FAIB	0.00					<u>20</u>	_6_	- ········	Jn 3-08-23
120 *120* QC Quality Control		QC8- Inspect parts - seco	nd check	0.00 0.00 2 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3	3				3	19		·

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									DQA:	Date:	•
NCR: Y	es / No				WORK ORDER NON-C	ONFO	RMANCE / UF	PDATE			
					<u> </u>				QA Closed:	Date:	
Work Orde	ir:				DISPOSITION		· · · .	AGAINST DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		i		Descri	ption of work order update	Initia	Ad	ction	Sign &		"
Cause	Date	Step	Qty	(or Non-conformance	Chief E	ng Desc	cription	Date	Verification	QC Inspector
Doc/Data								-			
Equip/Tooling				1							
Operator []								
Material			1								
Setup `											
Other											
Process											
Supplier]
Training [
Unapproved											
					F	AULT CA	TEGORY				
Landir	ng Gear			_	General				-		-
	Bending				Bend	Grai	n		Ovalized		Pressure/Forced
	Centre N	lot Conce	ntric to	O/S	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ection Incomplete		Part Incorre	ct	Weld
	Crushed	/Crimped			Burrs	Instr	uctions Incomplete	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mai	ntenance		Part Moved		
	Heat Tre	oat .			Countersink	Mist	holod		Positioned V	Mrong	

Misread

Out of Calibration

Outside Dimensions

Out of Sequence

Offset

Other

Power Loss/Surge

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde		5550		*105	550*	·					Page 2
Item ID: Revision ID: Item Name:	D3065-5 Step Lcg			Accept	*N900	040	100)*	Setup Star Stop	1.0	S1* S2*
Start Date: Required Date: Reference:	8/08/13 8/08/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:					
Approvals:		in:		Tooling: SPC (Y/N):	_	ate:]	Run Star Stop	1/7	R1* R2*
Sequence ID/ Work Center II 130 *130* HandFinish Hand Finishing	D	Operation Description Chemical Conversion Co	at per QS1005 4 .1	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty 19	Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control		QC3- Inspect Part Finish Memo		0.00 B & 26	, 3			19			<u>.</u>
150 *150* Packaging		Identify as per dwg & Sto	ock Location A	0.00				<u> 19</u>			£3/08/2

Packaging

												DQA:	D	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE			_		
<u> </u>									<u>.</u>		_	QA Closed:	Da	ate:	
Work Ord	or.					DISPOSITION				AGAINST D	Eſ	PARTMENT,	/PROCESS		
Part I	٠ ِ.ov					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Je d. Eng. Coor re/Packaging Supplie	E	Engineering Quality Other
	-		1		Dagari			nitial	۸.	ction	7	Cian 9			<u> </u>
Root		Data	C		1	ption of work order update					ļ	Sign &	Verification		QC Inspector
Cause	Н	Date	Step	Qty	•	or Non-conformance	L'n	ief Eng	Desc	cription	\dashv	Date	verincatio)[] 	QC inspector
Doc/Data	H			ļ							ļ				
Equip/Tooling	ļ		1								1				
Operator	Н														
Material	\vdash														
Setup	H														
Other	\vdash	,		1							ļ				
Process	⊢														
Supplier	\vdash														
Training	⊢														
Unapproved	ļ.		<u> </u>	<u>i </u>	<u> </u>		<u> </u>	T CATE	SOBA		_		<u> </u>		<u></u>
Land	na (Gear	_			General	701	CAIL	- CONT		_	<u> </u>	-		
Land	<u> </u>	Bending				Bend	Г	Grain		Г	\exists	Ovalized			Pressure/Forced
	\vdash	Centre N	ot Conce	ntric to		BOM/Route	\vdash	Hardwa	re	F	_	Over/Under	tolerance	\vdash	Temperature/Cure
	\vdash	Cracks	or conce	THIC TO	~, —	Broken/Damaged	\vdash	1	ion Incomplete	F		Part Incorred			Weld
	\vdash	Crushed/	Crimned		-	Burrs	\vdash	4	ions Incomplete	/Unclear	-	Part Lost/Mi		-	Wrong Stock Pulled
	\vdash	Cuffs	cimpeu		ļ	Contamination	\vdash	Mainte		-	_	Part Moved	-ν···ν _D	<u> </u>	J on B stock , dired
	\vdash	Heat Trea	-+		-	Countersink	-	Mislabe		<u> </u>	_	Positioned V	Vrong		
	\vdash	Inspectio		Tube	<u> </u>	Cut Too Short	-	Misread			-	Power Loss/	_		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde August-08-13 8		05550		*105	5550*					<u></u>	Page 3	
tem ID: Revision ID: Item Name:	D3065-5 Step Leg			Accept	*N900	040	100	* Seti	up Start Stop	171.	S1* S2*	
Start Date: Required Date: Reference:	8/08/13 : 8/08/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item 1 Customer:	D:			C44			
Approvals:	Process P QC:	lan:	Date:	Tooling: _ SPC (Y/N):		ate:		Rui	1 Start Stop	1/7	R1* R2*	
Sequence ID/ Work Center I	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Code	Qty	Reject Qty	Reject Number	Insp. Stamp	
160 QC		Мето		0.00				MC5	- 13-	<u> </u>	<u> </u>	

Quality Control

\$136.3J

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE			
											QA Closed:	Date	<u> </u>
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	_	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root						ption of work order update		Initial		tion	Sign &		
Cause Doc/Data		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desci	<u>ri</u> ption	Date	Verification	QC inspector
Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	T CATE	GORY				
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio	Crimped at n Strip in		D/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instructi Mainte Mislabe Misread	on Incomplete ions Incomplete/U nance Ied	Jnclear	Ovalized Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1	1	Ripples in	ı Bend		- 1	Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio August-08-13 8:58:31 AM

Work Order ID:

105550

Parent Item:

D3065-5

Parent Item Name:

Step Leg

Start Date: 8/08/13

Required Date: 8/08/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF

IPP Rev:D Now on Water Jet 06-04-11 JLM

P Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No	-	<u> </u>	100	sf	707.0000	0.825	17.368472			<u>1308</u> 23
				<u>Location</u>		Loc Qty	<u>Lo</u>	c Code				;	
				MAT021		707							
				125	812	34							
				m li	26309	364.5							
				m t	26350	308.5			120	6350			

												DQA:	Dat	e.	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE					
***												QA Closed:	Dat	e:	
Work Ord	er:					DISPOSITION				AGAINST D	DΕ	PARTMENT	PROCESS		
Part I	•					Rework Scrap] -		Skid-tube Machining	Crosstube Small Fab		4	Water Jet d. Eng. Coor.		Engineering Quality
NCR I	No.			<u> </u>		Use-as-is Work Order Update]	Therr	noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier		Other
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	۱, ۱	QC Inspector
Doc/Data															
Equip/Tooling	L													-	
Operator															
Material															
Setup									ļ						
Other	Ш				ĺ										
Process														-	
Supplier															
Training	\bigsqcup]												
Unapproved			<u></u>												
						F	AUL	T CATE	GORY						
Landi	ng (Gear				General		_				_	_		
ļ		Bending				Bend		Grain				Ovalized			Pressure/Forced
		Centre No	ot Concei	ntric to	O/S	BOM/Route		Hardwa	are			Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete			Part Incorred	:t 「		Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

H:/FORM\$/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Hotes

Drawing

Finish

Folio

DART AEROSPACE LTD	Work Order:	02220
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16.458			T	Jamos
15.750	+/-0.005	15.750"	_	. 1	T	
2.250	+/-0.005	2-252	-		V	
3.460	+/-0.005	3.461	-		V	
0.865	+/-0.005	0.866	+		V	
6.020	+/-0.005	(0.019"			V	
1.205	+/-0.005	1.206			V	
3.484	+/-0.005	3.486"	_		V	
0.871	+/-0.005	0.873	1		ν	
8.325	+/-0.010	8.327			ν	Productor
0.551	+/-0.010	0.550	_		U	
0.213	+0.005/-0.000	0.214	-		ν	
Ø0.128	+0.005/-0.000	0.138,)		V	

Measured by: Jm	Audited by:	£ 89	Prototype Approval:	N/A
Date: 308-23	Date:	13-8.00	Date:	N/A

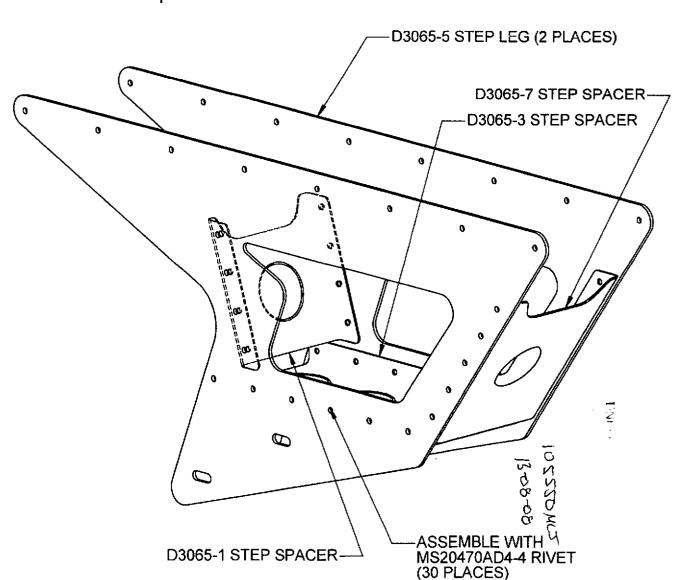
Rev	Date	Change	Revised by	Approved
Α	03.09.22	New Issue P/O D3065-041	KJ/RF	
В	04.06.15	Added Ø0.128 dimension	KJ/JLM 1.A	
С	06.06.23	Dwg Rev. changed	KJ/JLM OX	\(\int_{\int}\)

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DESIGN PRAWN BY				DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
	CHECK		APPROVED	DRAWING NO.	REV. B	
		PH	一板	D3065	SHEET 1 OF 5	
	DATE)C 00	TITLE	SCALE	
06.05.23)5.23 	STEP LEG ASSEMBLY	1:2	
	Α	0:	2.09.11	NEW ISSUE	"	
	В	06.05.23		ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5		

RELEASED



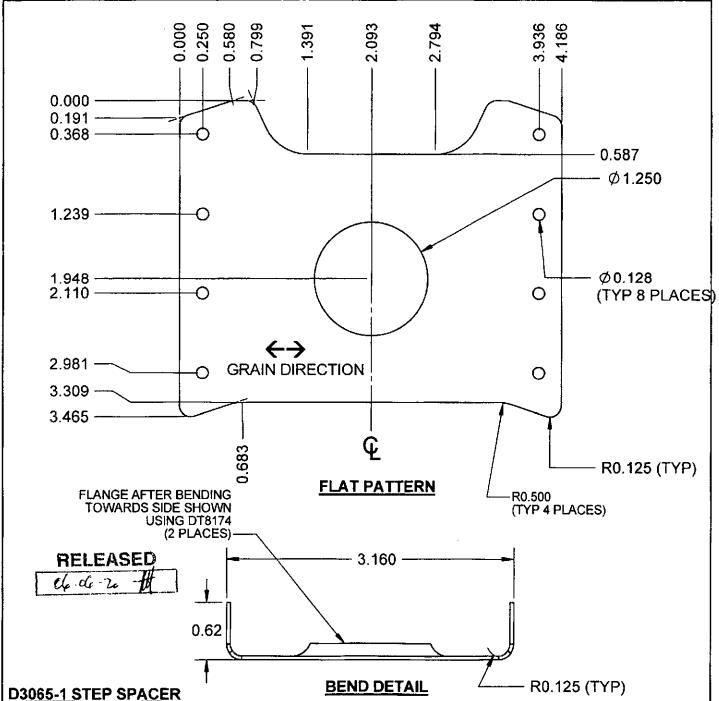
D3065-041 STEP LEG ASSEMBLY

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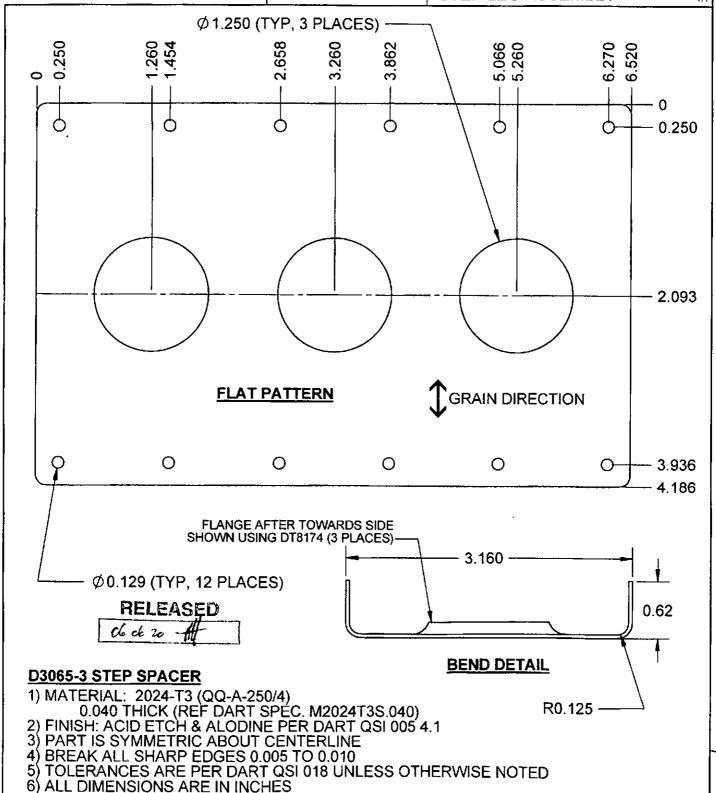
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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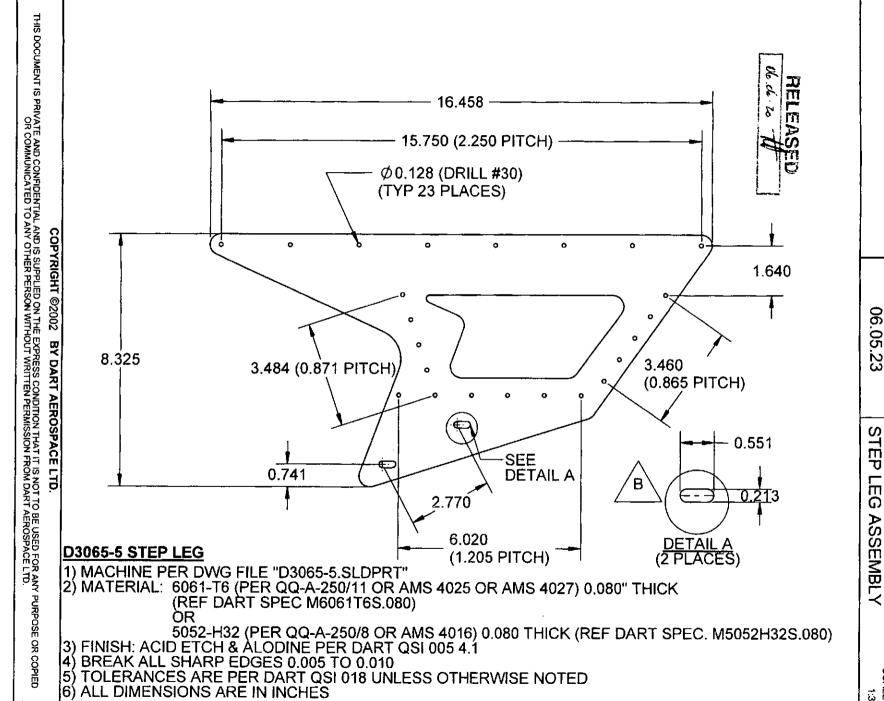




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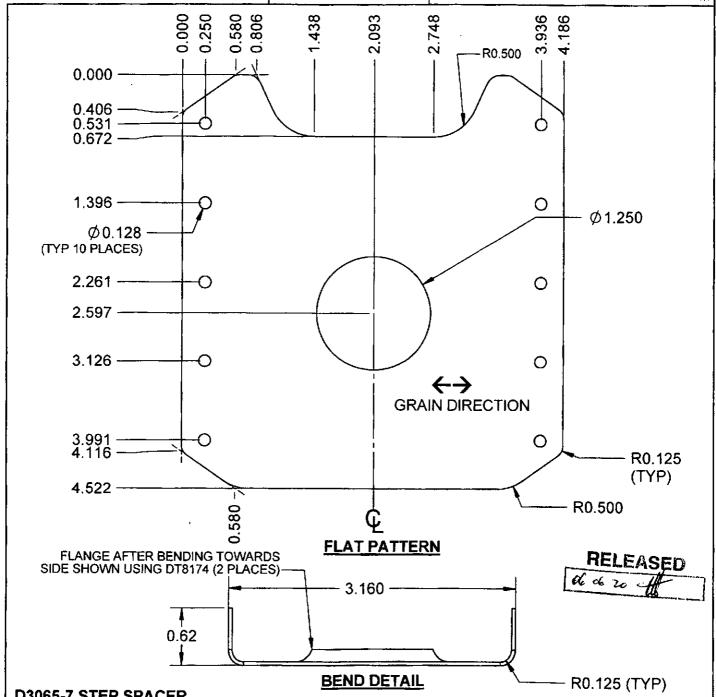




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D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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